

Work Order ID 158037

Tuesday, March 07, 2017 1:54:54 PM

158037

Page 1

Item ID: D206-559-033 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206L Series/407 Bearpaw Wearplates
 Start Date: 3/7/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/7/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference: SCHEDULE

Approvals: Process Plan:  Date: MAR 07 2017 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-559	REV L								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels per PPP D206-559-033	CHG 003							
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.01							
Quality Control									

Today

DAS
6
9-89

MAR 05 2017

DAS
28
9-89

DAS
21
9-89

MAR 07 2017

MAR 07 2017

DA
6
9-89

MAR 05 2017

DAS
27
9-89

DAS
28
9-89

MAR 07 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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								Completed By																	
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								QC / QA Coordinator Approval																	
Root Cause				FAULT CATEGORY																					
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Page 2

Item ID: D206-559-033**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** 206L Series/407 Bearpaw Wearplates**Start Date:** 3/7/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 3/7/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:** SCHEDULE**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00

120

Packaging

0.00

Packaging

Memo

Identify and pack for shipping as per PPP D206-559-033

Location: _____

PPP Rev: _____

DAS
28
9-89

MAR 07 2017

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.02

Quality Control

DAS
21
9-89

MAR 07 2017

DAS
21
9-89

MAR 07 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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3

Work Order ID: 158037

158037

Parent Item: D206-559-033

D206-559-033

Parent Item Name: 206L Series/407 Bearpaw Wearplates

Start Date: 3/7/2017

Required Date: 3/7/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev B
10.10.04 per DSI9527 EC verified by:DD IPP REV:C 14.05.01
AS PER ECN14-544 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A *AN4-17A* Bolt		Purchased	No			105	Each	160.0000	12	12			DAS 27 9-89
									**				
				<u>Location</u>				<u>Loc Qty</u>					
				over003				100					
					M136787			50					
					M136983			50					
				ST343				60					
					M136406			42					
					M136665			18					
AN4-20A *AN4-20A* Bolt		Purchased	No			105	Each	226.0000	12	12			DAS 27 9-89
									**				
				<u>Location</u>				<u>Loc Qty</u>					
				GA				6					
					m116419			6					
				over003				140					
					m136586			100					
					m136983			40					
				ST343				37					
					m135966			36					
					m136148			1					
				ST343				43					
					<u>m136665</u>			43					

DAS 27 9-89
MAR 05 2017
6 9-89

DAS 27 9-89
MAR 05 2017
6 9-89

DAS 28 9-89

DAS 28 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
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Work Order ID: 158037

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Parent Item: D206-559-033

D206-559-033

Parent Item Name: 206L Series/407 Bearpaw Wearplates

Start Date: 3/7/2017

Required Date: 3/7/2017

Start Qty: 1.00

Required Qty: 1.00

D3859-041

Manufactured No

105

Each

9.0000

2

2

D3859-041

Wearplate Assembly

**

DAS

6

9-89

MAR 11 5 2017

DAS

27

9-89

MAR 11 5 2017

DAS

28

9-89

Location

Loc Qty

Loc Code

ST610

9

147241

1

154510

8

2

MS21042L4

Purchased

No

105

Each

2,301.000

12

12

MS21042L4

Nut

**

DAS

6

9-89

MAR 11 5 2017

DAS

27

9-89

MAR 11 5 2017

DAS

28

9-89

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

187

m135058

187

OVER007

935

m136450

500

m136986

435

ST303

1161

m136648

161

m136838

1000

12

Tuesday, March 07, 2017 1:54:59 PM

Shop Packet Print

Page 2

MAR 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Work Order ID: 158037

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Parent Item: D206-559-033

D206-559-033

Parent Item Name: 206L Series/407 Bearpaw Wearplates

Start Date: 3/7/2017

Required Date: 3/7/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

105

Each

3,320.000

12

12

NAS1149D0463.J

Washer

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Location	Loc Qty	Loc Code
GA	80	
M134508	13	
M135056	67	
ST2360A	1000	
M136983	1000	
ST260a	1000	
M136838	1000	
ST263	1240	
M136665	1240	

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 158037

Tuesday, March 07, 2017 2:01:40 PM

158037

Page 1

Item ID: D206-559-033 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206L Series/407 Bearpaw Wearplates
Start Date: 3/7/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/7/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULE

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-559	REV L								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels per PPP D206-559-033	CHG 003							
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.01							
Quality Control									

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REFERENCE ONLY

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D206-559

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

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Revision: L
Date: 11.04.08